

IN THE SUBSTITUTE SPECIFICATION

Please cancel paragraphs 031, 069, 086, 088 and 095 of the Substitute Specification, as filed. Please replace those cancelled paragraphs with replacement paragraphs, also 031, 069, 086, 088 and 095, as follows:

[031] In a preferred embodiment of the present invention, the transport system 19 additionally has at least one transport track 33 extending to a storage space 34, which storage space 34 is acting, for example, as the transfer station 34, of the inner or central shelf block 24 . For this purpose, the outer shelf block [[24]] 22 has an access, such as, for example, a passage, or the outer shelf block [[24]] 22 does not extend over the same length of the inner shelf block 24, such as is the case in the preferred embodiment depicted ~~in Fig.~~ in Fig. 2. Rolls of material coming from the stock reception arrangement, such as, for example, not yet prepared material rolls, can be stored either in the outer shelf block 22 or in the inner shelf block 24.

[069] The stored material rolls can be stored in the delivered state or unprepared ~~or unprepared~~ and are prepared in the depot 21 for use in production by appropriate devices and methods, in the preparation circuit 35. The production preparation substantially relates to unpacking and to preparation for automatic gluing, as has been discussed previously.

[086] In a parallel process, which is a removal process, material and return requests are registered by the press 01, such as, for example, in the roll changer 06 and are checked to determine whether they can be met. If yes, the request is met. In an advantageous embodiment of the present method, in the case of a shortage, it is provided to check the stock for similar roll types or articles ~~or articles~~ and, in the case of a positive result, to provide the press 01 with them. Otherwise, for example, the immediate storage of a roll of matching type takes place, which roll, in this case, should be passed through as quickly as possible from the stock reception arrangement 18, by way of the preparation circuit 35, the inner or center shelf block 24, as well as the shelf block 23 which is close to the presses. In an advantageous embodiment of the present invention, the definition, which is for the decision to be made in Fig. 4 regarding a "similar article" or roll, is stored in a table.

[088] The redeposition strategy, which is identified as the "useful production-oriented redepositioning" in Fig. 4 is determined in the partial process, identified as "redepositioning," in that initially the storage capacity is determined and a differentiation is made between low, normal and high storage occupations. As a function of this determination and differentiation, in the case of low occupancy, the rolls are stored in a path-optimized way under the premise of minimal redepositioning, a premise that redepositioning should be avoided if possible. With

normal occupancy, the rolls are stored in a path- and space-optimized way, wherein needed redepositioning is permissible. With high occupancy, the rolls must be stored in a space-optimized, wherein redepositioning takes place in accordance with production requirements. Optimization, with regard ~~with regard~~ to path and/or to space and/or to the number of redepositioning processes, can take place by the use of mathematical algorithms, which search for states of a local or an absolute minimum for the respective, possibly weighted variable or variables, while taking marginal conditions into consideration. This can take place while considering only the next step, such as, for example, the movement of a single roll, but in an advantageous, forward looking manner can take place by considering several pending storing and/or removal processes, so that an optimized strategy is developed as a whole. In the ideal case, the entire upcoming production period is included in the determination of the strategy so that, even if individually observed redepositioning steps, occurring within a short period of time, and considered by themselves, such as, for example, at the start would not represent an optimal solution, the entire process, as a whole, results in an optimal run.

[095] A total process for the storage of unprepared and of prepared rolls of material for use in the web-fed rotary printing press now can be advantageously configured in such a way that

production-relevant data regarding planned production runs, such as an amount ~~an amount~~ of paper, and/or type, and/or time, are transmitted directly from the production planning system 03, or via the press 01 to be supplied, by a signal connection, to the computing and/or data processing unit 17. In a first partial process, the determination of a storage strategy and, depending on the requirements, a storage request for fresh, unprepared rolls of material takes place. This is done through the computing and/or data processing unit 17 on the basis of the transmitted usage data for the pending length of production time and the actual amount stored. A determination of a production preparation time for unprepared rolls of material is made by the logic device implemented in the material supply system 05, taking into consideration a limited shelf life of the gluing preparation and the planned production time. In a second partial process, requests for rolls of material made by the press 01 are directed to the material flow system via a signal connection. These requests are registered in the system's computing and/or data processing unit 17 and are checked there on the basis of available data regarding the storage content for availability from the depot 21. In case of a positive result, an order, in accordance with the request from the press 01, is forwarded directly via the material flow system 05 or via a depot administrative system for a transfer to a serving element 29, 30 of the depot 21. In a third partial process, on the basis of the transmitted production-relevant data regarding the planned

requirements, the storage status is checked by the material flow system 05 in such a way that the prepared and unprepared rolls of material of the required types of rolls are positioned in a production-optimized way. The result is that, in accordance with the planned requirements, a strategy for the production- oriented shifting of unprepared and prepared rolls within the depot 21 is determined and is executed.